

SHIP TODAY 07/feb.

Work Order ID 96847

96847

Page 1

February-07-13 9:09:28 AM

Item ID: D4012-1

Accept

N900040100

Setup Start *NS1*

Revision ID:

Stop *NS2*

Item Name: Cushion

Start Date: 2/07/13

Start Qty: 6.00

6

Cust Item ID:

Required Date: 2/07/13

Req'd Qty: 6.00

6

Customer:

Reference:

Approvals:

Process Plan: 

Date:

Tooling:

Date:

Run Start *NR1*

QC:

Date:

SPC (Y/N):

Date:

Stop *NR2*

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

D4012

B

100

0.00


100

Mill Conv

Memo

0.00

Conventional Milling Machine

 13/02/07

6

110

QC2- Inspect parts off machine FAI/FAIB

0.00


110

QC

Memo

0.00

Quality Control

 13-02-07
M.P 13/02/07

6

120

QC8- Inspect parts - second check

0.00


120

QC

Memo

0.00

Quality Control

 13/02/07

6

Work Order ID 96847

February-07-13 9:09:28 AM

96847

Page 2

Item ID: D4012-1 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Cushion
 Start Date: 2/07/13 Start Qty: 6.00 ***6*** Cust Item ID:
 Required Date: 2/07/13 Req'd Qty: 6.00 ***6*** Customer:
 Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
123 *123* Small Fab	Memo	0.00				6			SP 13/02/07
Small Fab	CLAMP AND FORM CUSHION AS PER DWG BY SLIGHTLY HEATING IT WITH HEAT GUN, LET IT COOL DOWN BEFORE REMOVING CLAMP.	0.00							
126 *126* QC	QC5- Inspect part completeness to step on W/O	0.00				6			
Quality Control	Memo	0.00		Smd B2-7					
130 *130* Packaging	Identify as per dwg & Stock Location: <u>ST450</u>	0.00				60X			SP 13-2-7
Packaging	Memo	0.00							

Work Order ID 96847***96847***

Page 3

February-07-13 9:09:28 AM

Item ID: D4012-1

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N900040100Setup Start ***NS1***

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Item Name: Cushion

Start Date: 2/07/13 Start Qty: 6.00

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Cust Item ID:

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Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start ***NR1***

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
140	QC21- Final Inspection - Work Order Release	0.00							
140									
QC	Memo	0.00							
Quality Control									

MLJ 13-02-07
MK
13-2-07

Picklist Print

February-07-13 9:09:27 AM

Page 1

Work Order ID: 96847

Parent Item: D4012-1

Parent Item Name: Cushion

Start Date: 2/07/13

Required Date: 2/07/13

Start Qty: 6.00

Required Qty: 6.00

Comments: IPP RevA: New issue 09.10.28 DD verified by:JLM
09.11.18 DD verified by:JLM
by:JLM
IPP RevB: revA as per dwg
IPP Rev:C 11.01.10 as per dwg Rev.B DD verified

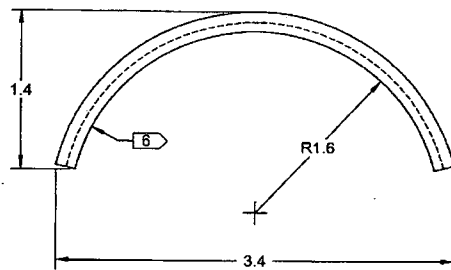
Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D4287-3 UHMW U-Channel		Manufactured	No			100	f	14.4000	0.37	2.3368421			

Location	Loc Qty	Loc Code
MAT051	8	
94940	8	
ST202	6.4	
91102	6.4	

13/02/04

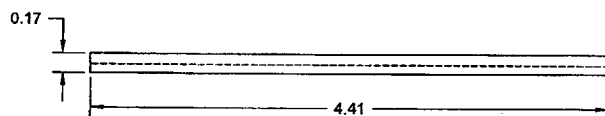
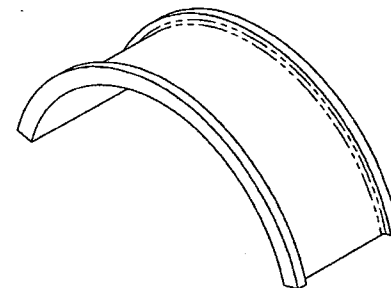
4.0

[Signature]

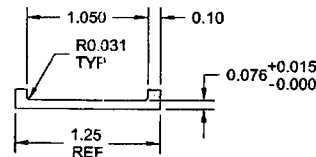


D4012-1 CUSHION
 (MAKE FROM D4012-1F)

W/O 96847



D4012-1F FLAT MACHINED STATE 1



RELEASED
 2010-12-23
 JMB

NOTES:

- 1) MATERIAL: MAKE FROM D4287-3
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D4012-1" AND B/N "BXXXXX" PER QSI 044 6.1
- 7) WEIGHT: 0.02 lbs

B	CHANGED RAW MATERIAL TO REDUCE MANUFACTURING COSTS; PART NOW MACHINED FLAT AND SHAPED WITH RADIUS. REF: PAR10-29	MB	10.12.07
A	NEW ISSUE	MB	09.10.19
REV.	DESCRIPTION	BY	DATE
DESIGN			
DRAWN			
CHECKED			
MFG. APPR.			
APPROVED			
DE APPR.			
DATE	10.12.07		

DART AEROSPACE LTD
 HAWKESBURY, ONTARIO, CANADA

DRAWING NO.
D4012

REV. B
 SHEET 1 OF 1

TITLE
CUSHION

SCALE
 NTS

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